Date: User: Customer This Issue Prsht Rev. First Issue **Previous Run** Written By Comment Job Number:

Thursday, 29/05/2008 11:04:57 AM Julie Lecocq

Process Sheet

: CU-DAR001 Dart Helicopters Services

Job Number : 39561 **Estimate Number** : 10993

P.O. Number

: 29/05/2008

: 38659

: NC : 11 S.O. No. :

Type

: MACHINED PARTS

Checked & Approved By

Now turned on Cobra NG 02.06.17

est F 07.07.06 rev E dwa

Additional Product

Seq. #:

6061-T6 Tube .500 x.058W

Description:

1.0

2.0

3.0

5.0

Comment: Qty.:

M6061T6T0500W058

0.3762 f(s)/Unit Total: 188.1075 f(s)

6061-T6 Tube .500 x.058W

Material: 6061-T6 (WW-T-700/6) or 5052-H32 (WW-T-700/4)

0.500 Dia x 0.058 Wall

Batch M 1079

HARDINGE CNC LATHE SMALL

Comment: HARDINGE CNC LATHE SMALL

Machine as per Folio FA245

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8

HARDINGE

SECOND CHECK



Comment: SECOND CHECK

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock BANC GY



: CROSSBOLT SPACER

: D2579

. D2579 REV E

: N/A **Project Number Drawing Revision** : E

Material

Drawing Name

Part Number

Drawing Number

Due Date : 10/06/2008

Qtv:

. 08/06/01

500 Um:

Each

Page 1

Dart Aerospace Ltd

	WORK ORDER CHANGES							
STEP PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
	:							
	STEP	STEP PROCEDURE CHANGE	STEP PROCEDURE CHANGE By	STEP PROCEDURE CHANGE By Date	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr		

Part No:	_ PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C C	losed:	Date:

	V	ORK OR	DER NON-CONFORMANC	E (NCR)			
	Description of NC		Corrective Action Section B	Varification	Ammental		
STEP	Section A			Sign & Section C		Chief Eng	Approval QC Inspector
		·					
	43.		·				
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Section A Initial Action Description Sign & Verification Section C	STEP Description of NC Section A Portion Description Section B Verification Approval Chief Eng

NOTE: Date & initial all entries

Date:

Thursday, 29/05/2008 11:04:57 AM

User: +

Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 39561

Part Number: D2579

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21



FINAL INSPECTION/W/O RELEASE



08/06/03/

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U Nula 03

Dart Aerospace Ltd

W/O:		WORK ORDER CH	WORK ORDER CHANGES						
DATE STEP		PROCEDURE CHANGE	(4)	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		H							

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C C	losed:	Date:

NCR:		\	VORK OR	DER NON-CONFORMANC	E (NCR)			
		Description of NC		Corrective Action Section B	Verification		A	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
								. •
(-)								
								(4)
			1					

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 39561	
Description: Cross Bolt Spacer	Part Number: D2579	9
Inspection Dwg: D2579 Rev: E	Page 1 d	of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype							
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments	
4.070	+/-0.030	4.073"				1	
0.058	+/-0.010	1,060"				_	
			-				

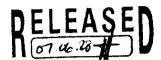
Measured by: J. F.	Audited by:	Prototype Approval:	N/A
Date: 08/05/31	Date: 08/05/3)	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.11.27	New Issue	KJ/RF	
В	07.09.06	Dwg Rev updated	KJ/JLM X	E
			7()	

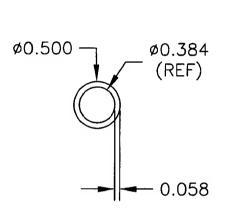
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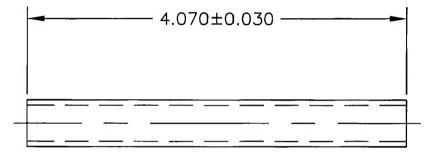


DESIG	N ##	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANAD	
CHEC	KED #	APPROVED	DRAWING NO. D2579	REV. E SHEET 1 OF 1
DATE	<u> </u>		TITLE	SCALE
07.0	04.17		CROSS BOLT SPACER	1:1
Α		96.09.16	NEW ISSUE	
В		96.12.05	0.065 WALL WAS 0.035 WALL	



	07.04.17		CROSS BOLT SPACER 1:1
	Α	96.09.16	NEW ISSUE
	В	96.12.05	0.065 WALL WAS 0.035 WALL
	С	97.02.21	0.058 WALL WAS 0.065 WALL
	D	99.05.19	4.070 LENGTH WAS 4.100 (TSR A1095)
	E	07.04.17	UPDATE NOTES





D2579 CROSS BOLT SPACER

D2579 CROSS BOLT SPACER

MATERIAL:

6061-T6 TUBING PER WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8

(REF DART SPEC M6061T6T0500W058)

2) FINISH: NONE

3) ALL DIMENSIONS ARE IN INCHES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE

WORK ORDER

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